

Work Order ID 55091

Page 1

January 5, 2010 3:16:45 PM

Item ID: D3823-3KGY

Accept



Setup Start



Revision ID:

Item Name: Overhead Rear, Center-Grey

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100



HandThermo

Hand Finishing Thermoforming

Memo

0.00

0.00

1-Cut Sheet to required Blank size

 10/01/27

110



Thermoform

Thermoforming Machine

Memo

0.00

0.00

 1-Machine Set-Up
 2-Pre-heat Tool to required temp.
 3-Thermoform as per Dwg and Folio #FTA031 using tool DT9110

Dwg Rev:

Folio Rev:

 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC



Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

PB
10/01/27
X1

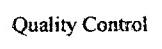
130



QC8- Inspect parts - second check

0.00

QC



Memo

0.00

Quality Control

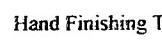
PL 10/01/27
CO

140



0.00

HandThermo



Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

PL 10/01/28
X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

W 10/01/20

X1

160

QC5- Inspect part completeness to step on W/O

0.00

z) 10/01/28



QC

Memo

0.00

Quality Control

X1

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

10-1-28 ⑩ sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/2010
MF

10-1-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

January 5, 2010 3:16:49 PM

Work Order ID: 55091**Parent Item:** D3823-3KGY**Parent Item Name:** Overhead Rear, Center-Grey**Start Date:** 05/01/2010**Required Date:** 05/01/2010**Comments:****Start Qty:** 1.00**Required Qty:** 1.00

Component Item ID/ Item Name	Replacemen t Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	519.7508	10.6303			

Kydex steel grey

**Warehouse****Location****Main Warehouse**

MAT

111807

Loc Qty

519.7508

519.7508

Loc Code
10/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55691
Description: Rear Overhead, Center	Part Number:	D3823-3KIV/KGY
Inspection Dwg: D3823 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *Dh*

Date: 10/01/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	0.520"	✓			
0.75	Min	0.844"	✓			
0.36	Min	0.490"	✓			
0.50	Min	0.604"	✓			
0.045	Min	0.050"	✓			
0.055	Min	0.060"	✓			

Measured by: *Dh*

Date: 10/01/28

Audited by: *S. Rebo*

Date: 10/01/28

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

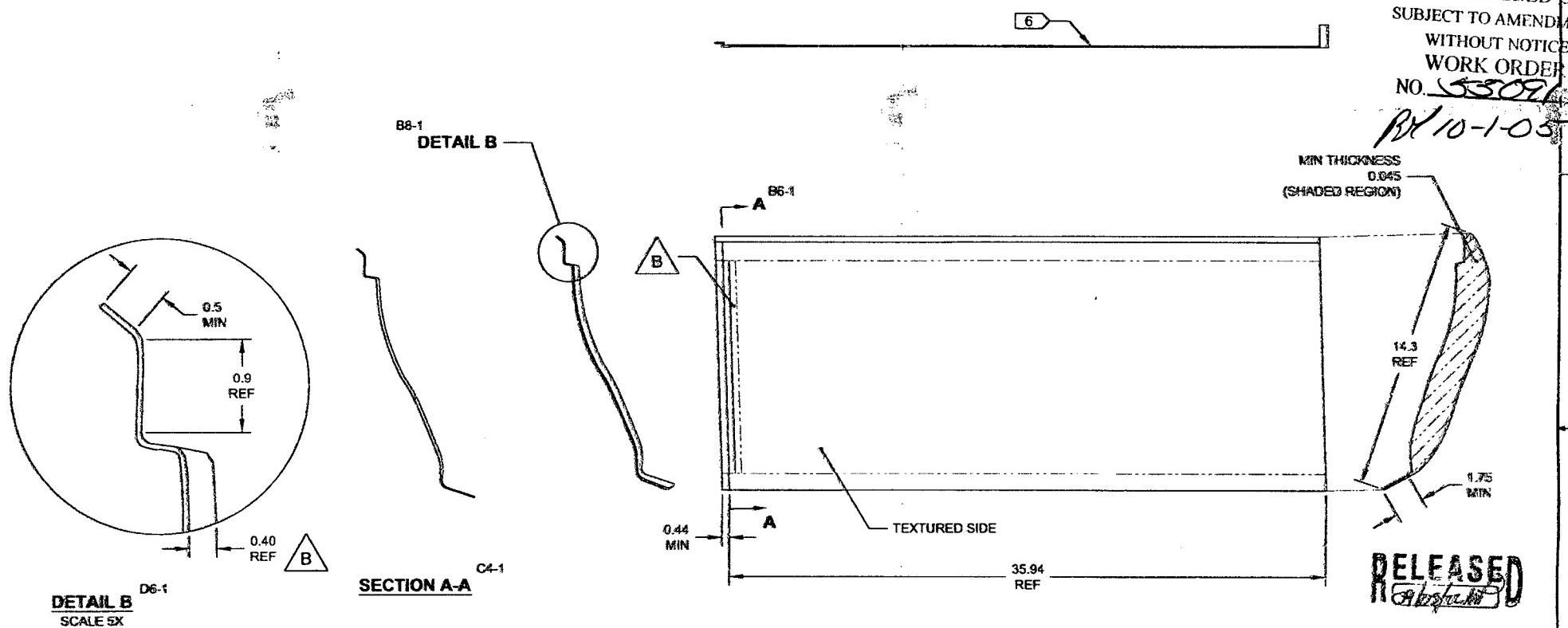
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 55309

BY 10-1-05



DETAIL B
SCALE SX

D3823-1 REAR OVERHEAD, LH

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY PINS D3823-1-2-3(KIV) AND ADD STEEL GRAY PINS D3823-1-2-3(KGY) (ZN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1-2-3 FOR BETTER FIT WITH D3824-1-3 HAT BIN (ZN C5-1, C5-2, C6-3); 0.40 WAS 0.16 (ZN B5-1, D7-2); 0.45 WAS 0.29 (ZN B5-3)	PH	09.02.09
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3823	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REAR OVERHEAD	NTS
DATE	09.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS RESTRICTED TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISCLOSED TO UNAUTHORIZED PERSONS WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055 UNLESS OTHERWISE NOTED

C
C

PART NUMBER	DESCRIPTION
D3823-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #52015 (MKYD6185S.080-P3-62015)
D3823-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

8 7 6 5 4 3 2 1

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

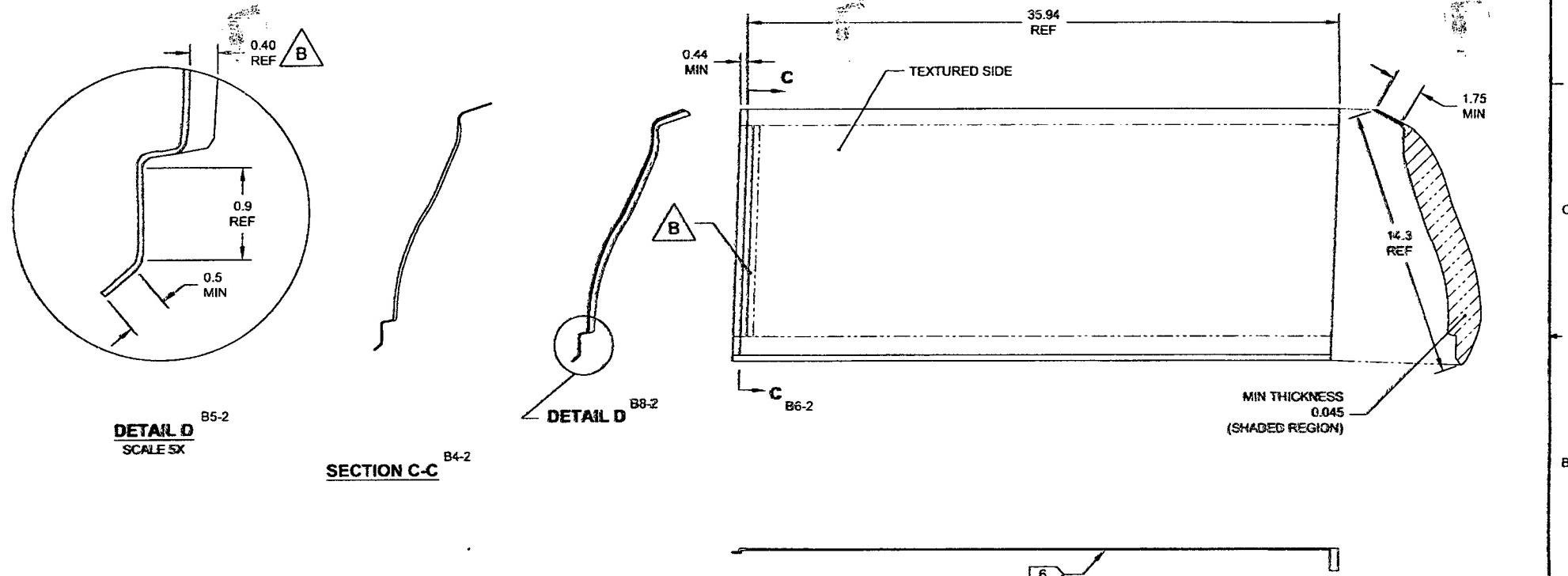
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1 1



D3823-2 REAR OVERHEAD, RH

RELEASED
09/03/2014

NOTES

- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: .005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 1.9 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3823-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (KYD6185S.080-P3-62015)
D3823-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (KYD6185S.080-P3-52068)

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD		
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>[Signature]</i>	D3823	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	REAR OVERHEAD	NTS	
DATE	09.05.05	COPYRIGHT © 2005 DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASABLE ONLY ON THE EXPRESS CONDITION THAT IT IS NOT USED FOR ANY PURPOSE UNLESS APPROVED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

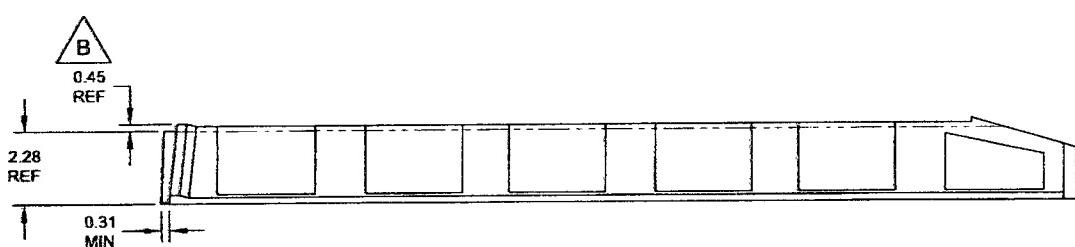
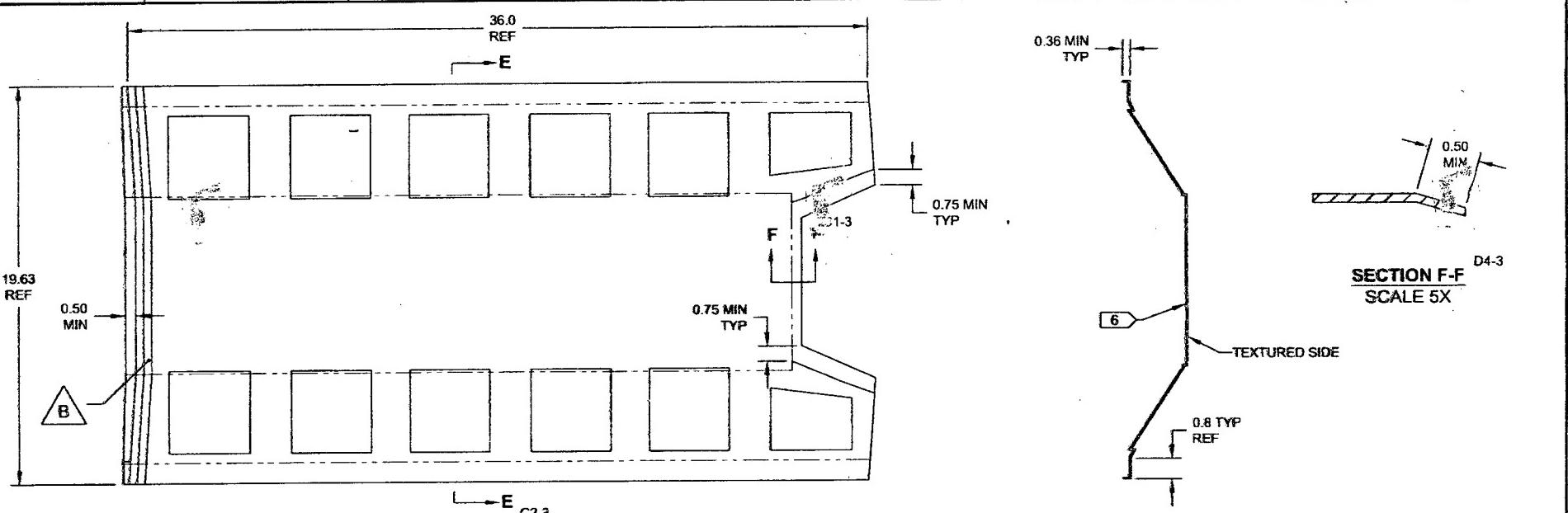
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

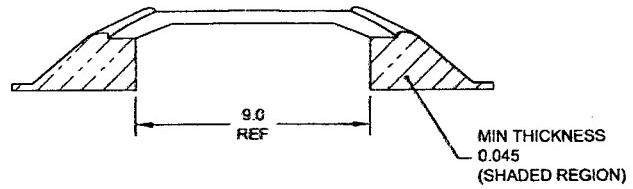
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



D3823-3 REAR OVERHEAD, CENTER

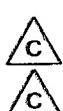


W/0 55091

RELEASED
07/05/2010

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9110 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3823-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	REF	DART AEROSPACE LTD
DRAWN	REF	HAWKESBURY, ONTARIO, CANADA
CHECKED	REF	REV. C
MFG. APPR.	REF	D3823 SHEET 3 OF 3
APPROVED	REF	TITLE
DE APPR.	REF	SCALE
DATE	09.05.05	NTS

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